

Work Order ID 64986

Wednesday, January 05, 2011 1:01:34 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

1-10-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*ES 11/03/10 ①**ES 11/03/10 ②**M 11 03 10 ①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64986



Page 2

Wednesday, January 05, 2011 1:01:34 PM

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PDP
64992

0.00

Packaging

1/12/11

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11

MF

11-03-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 1:01:39 PM

Page 1

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)






Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC
revC DD 10.08.18 verified by:EC
IPP Rev:B as
IPP Rev:C as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	0.0000	1	1			
D2535  Spring		Manufactured	No			100	Each	64.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		64							
				58331		24							
				64280		40							
D2537  Bushing		Manufactured	No			100	Each	36.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		36							
				62393		6							
				64064		30							
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			

B65094 (1X)



ES 11/03/10



ES 11/03/10

ES 11/03/10

B64988 (1X)



ES 11/05/10

B64990 (1X)



ES 11/03/10

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3

Manufactured No

100 Each

30.0000

6



Washer



ES 11/03/10

Location

Loc Qty

Loc Code

ST095

29

64589

29

ST096

1

57144

1

66903 (6x)

D3953-3

Manufactured No

100 Each

1.0000

2



Gas Spring Stud, Lid



ES 11/03/10

Location

Loc Qty

Loc Code

ST100

1

64020

1

65620 (2x)

D3953-7

Manufactured No

100 Each

1.0000

2



Spring Spacer



ES 11/03/10

Location

Loc Qty

Loc Code

ST101

1

63674

1

365621 (2x)

D3953-9

Manufactured No

100 Each

13.0000

2



Gas Spring Washer



ES 11/03/10

Location

Loc Qty

Loc Code

ST100

11

64450

11

ST103

2

60008

2

B66162 (2x)

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No 100 Each 5.0000
Gas Spring Spacer



2

EP 5/10/3/10
365138 (2x)

Location	Loc Qty	Loc Code
ST101	5	
57143	1	
64021	4	

D3953-19 Manufactured No 100 Each 22.0000
Gas Spring Bracket



1

EP 5/10/3/10

Location	Loc Qty	Loc Code
ST	3	
59213	3	
ST097	19	
64810	19	

D3953-21 Manufactured No 100 Each 11.0000
Gas Spring Bracket



1

EP 5/10/3/10
6611P (2x)

Location	Loc Qty	Loc Code
ENG	5	
56407	5	
ST102	6	
57145	2	
59214	4	

D3969-3 Manufactured No 100 Each 20.0000
Spring (Basket Lid)



1

EP 5/10/3/10

Location	Loc Qty	Loc Code
ST272	20	
64285	20	

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Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-14A Purchased No 100 Each 72.0000



Bolt

4 4



EP 5/1/03/10

Location

Loc Qty

Loc Code

ST351

72

114941

22

115108

50

AN3-16A Purchased No 100 Each 108.0000



Bolt

2 2



EP 5/1/03/10

Location

Loc Qty

Loc Code

ST352

108

114752

58

116419

50

AN5-17A Purchased No 100 Each 58.0000



Bolt

4 4



EP 5/1/03/10

Location

Loc Qty

Loc Code

ST339

58

115594

8

116003

50

AN4-12 Purchased No 100 Each 32.0000



Bolt

3 3



EP 5/1/03/10

Location

Loc Qty

Loc Code

ST357

32

114784

7

116419

25

M116590 (4X)

M116786 (1X)

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 6

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,185.000

4

4



Nut



EP 11/03/10

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1159

115156

5

115594

500

116104

158

116105

496

1

MS24665-151

Purchased

No

100

Each

574.0000

3

3



Cotter Pin



EP 11/03/10

Location

Loc Qty

Loc Code

ST309

574

17566

574

3

MS24665-300

Purchased

No

100

Each

32.0000

2

2



Cotter Pin



EP 11/03/10

Location

Loc Qty

Loc Code

ST309

32

110123

32

2

Wednesday, January 05, 2011 1:01:39 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Wednesday, January 05, 2011 1:01:39 PM

Page 7

Work Order ID: 64986

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P Purchased No 100 Each 238.0000 6
Washer

Location	Loc Qty	Loc Code
ST275	238	
112940	92	
114405	1	
114576	4	
114718	2	
116169	1	
116391	138	

6
6
EP 1/11/03/10

NAS1149F0563P Purchased No 100 Each 158.0000 4
Washer

Location	Loc Qty	Loc Code
ST298	158	
114576	158	

4
4
EP 1/11/03/10

NAS1149F0332P Purchased No 100 Each 319.0000 8
WASHER

Location	Loc Qty	Loc Code
ST275	319	
18057	319	

8
8
EP 1/11/03/10

NAS1149C0432R Purchased No 100 Each 208.0000 2
Washer

Location	Loc Qty	Loc Code
ST297	208	
114292	50	
114742	67	
116304	91	

2
2
EP 1/11/03/10

M116737 @

Wednesday, January 05, 2011 1:01:39 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

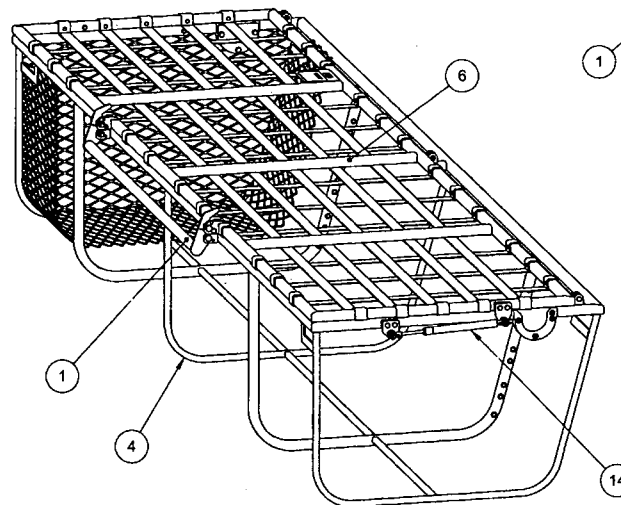
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

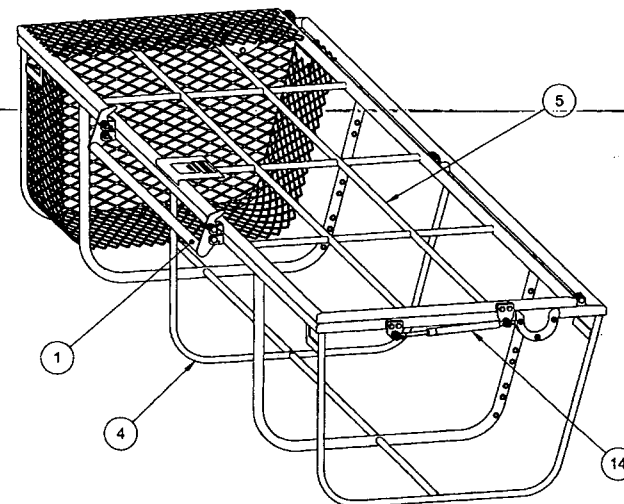
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6	1	1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2	2	AN3-16A	BOLT
17	2	2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	4	AN5-17A	BOLT
20	2	2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. C4984
28 11-01-5



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12 6
ECN 10-596

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	J	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

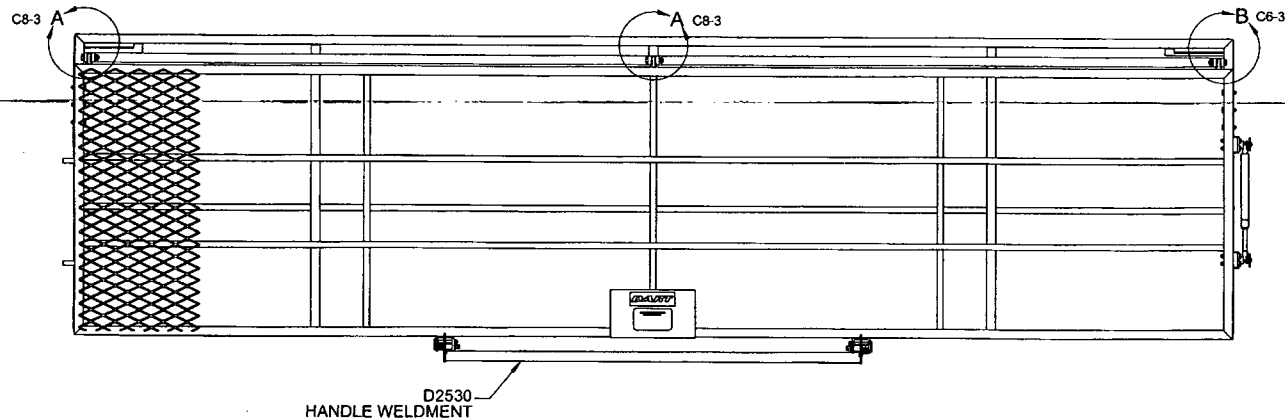
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

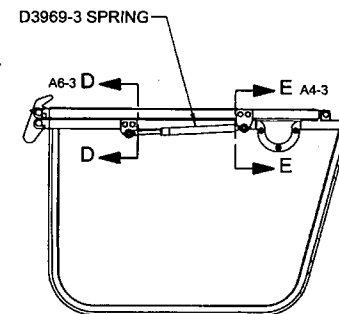
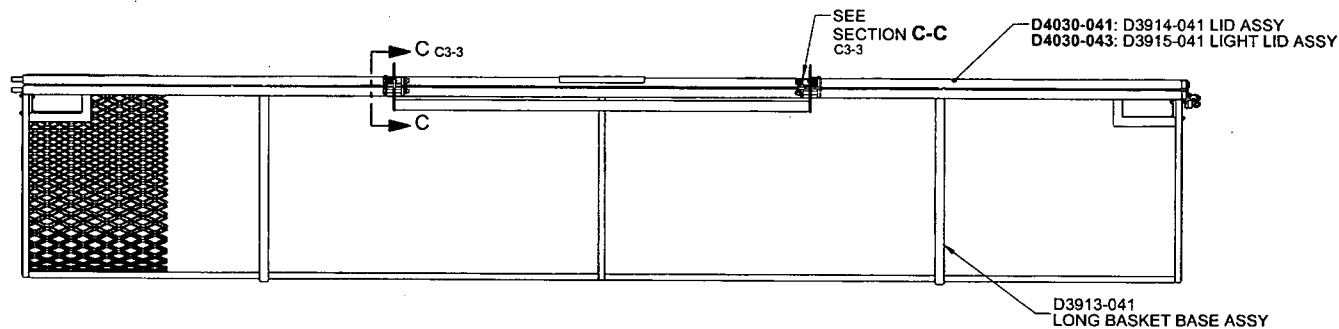
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



Wb 44984



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TR	DRAWING NO.	REV. C
MFG. APPR.	SE	D4030	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350) _ _ _ NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

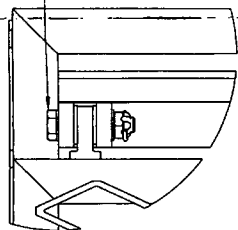
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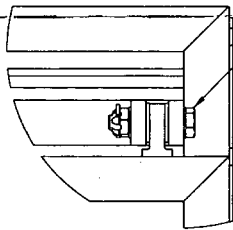
8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



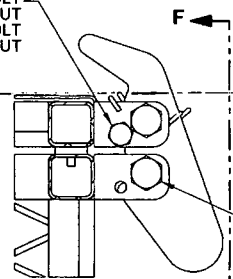
DETAIL A D8-2
D5-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT

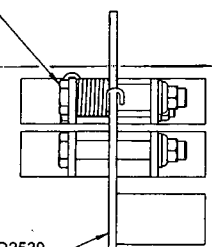


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

w/o 44984

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	JRS	D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries